

Date: Monday, 6/12/2006 2:33:44 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID		
Job Number	: 27520B		Part Number	: D2512		
Estimate Number	: 10193		Drawing Number	: D2512 REV D2		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/12/2006 S.O. No. : N/A		Drawing Revision	: D2		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 6/30/2006 Qty: 1 Um: Each		
Previous Run	: 27487A					
Written By	: <i>See Comment Below</i>					
Checked & Approved By	: <i>RF 06.06.12</i>					
Comment	: Rev Est:M 08.01.31 Added D2012-117 for D130-701-041 KJ/RF					
	Est Rev:N 06.04.05 Added level21		EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W 
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s) <i>(2.54)</i> CPL 06.06.13 Pick: 3/4"x3/4" 304/316 SS tube .063" wall <i>4.25</i> Batch: <i>M100023 → 51" M10111 → 467,53 3.96 (1493)</i>
2.0	D31663	Basket Hoop 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3166-3 Basket Hoop <i>B27327</i> CPL 06.06.12
3.0	D2506	Placard 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2506 Label Plate <i>B26631-2</i> CPL 06.06.16
4.0	D23271	Spacer Bushing 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2327-1 Bushing <i>B24742</i> CPL 06.06.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CPC 06.06.16

Pick:

Qty Part Number Description Batch  
2 D2232-1 Hinge plate

B25238

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CPC 06.06.16

Pick:

Qty Part Number Description Batch  
2 D2581 Mounting Bracket

B26204

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

CPC 06.06.17

Pick:

Qty Part Number Description Batch  
18 sf M304EX0.75-16F Expanded Metal

M100999 M100981

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

CPC

06.06.23

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig D18305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

9.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION

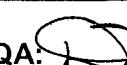


PD 06.06.27 ①

Comment: DDIMENSIONAL & WELDING INSPECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 

Date: 06/07/07

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27520B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/30/06 ①

11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Spray Paint Wing Walk  
Batch: M101032 R101266 FC 06/07  
04

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEICAL CONVERSION

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/A

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/07/07

Job Completion



① 06/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



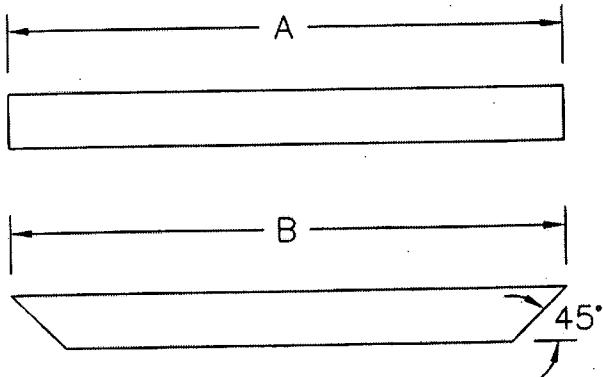
DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) NTS	

**RELEASED**  
01.04.27 *CP*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	<del>CP</del> 03.01.20	ADD D2012-117 FOR D130-701-041
D2	<del>CP</del> 04.09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

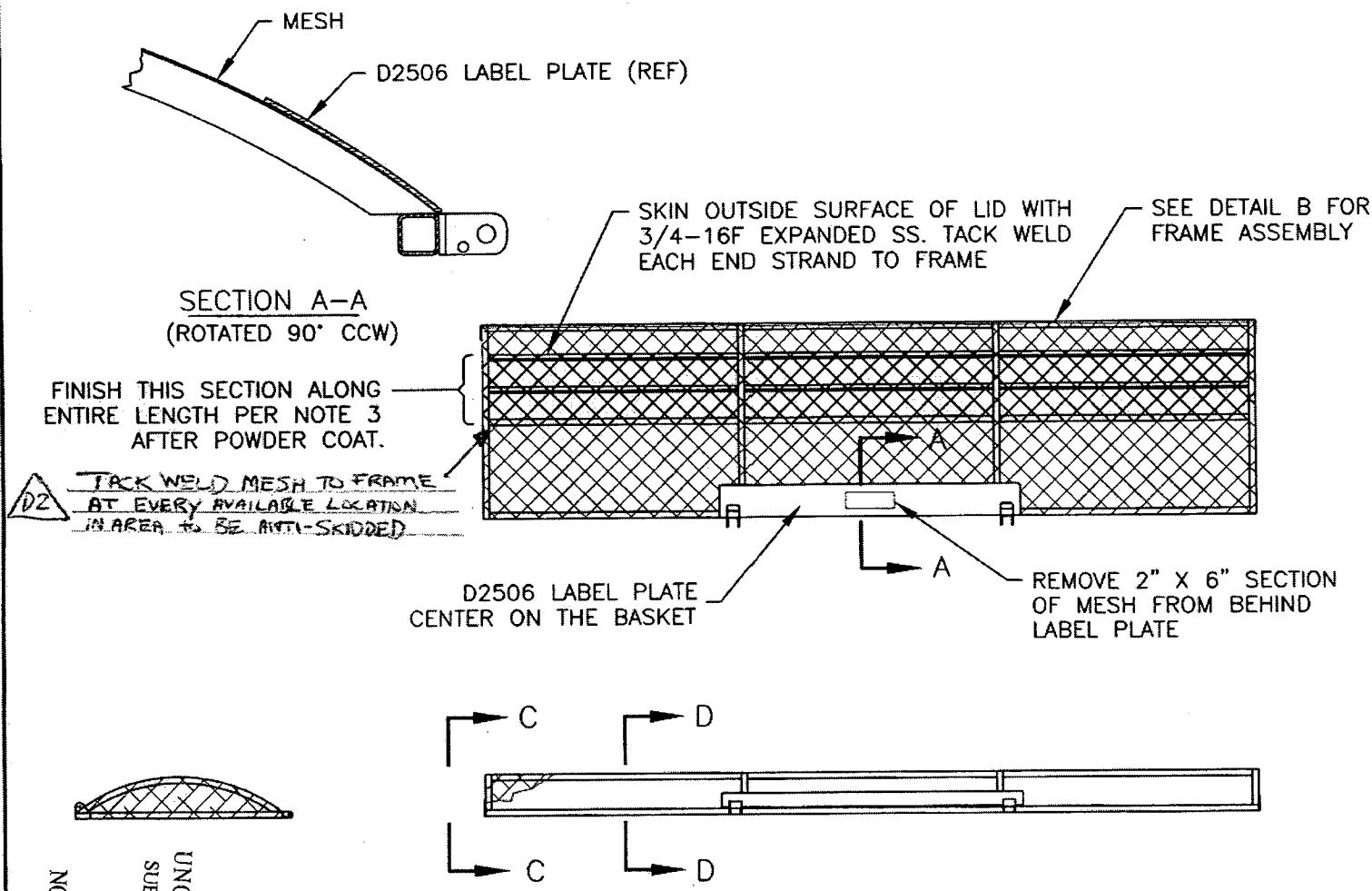
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WORK ORDER NO. 2520 B



D2512 BASKET LID ASSEMBLY

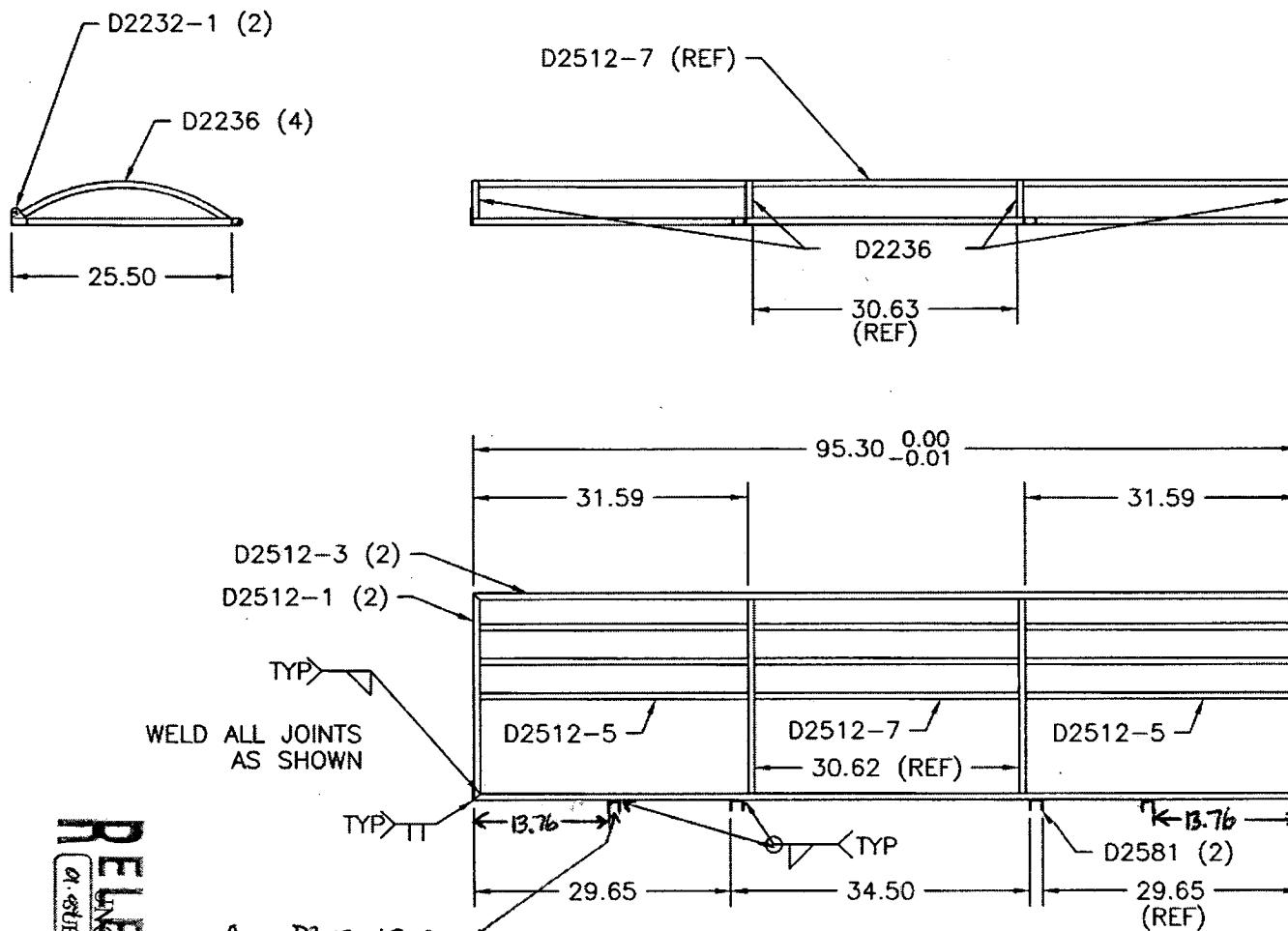
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

<b>DART</b>		DRAWN BY <i>JP</i>	DART AEROSPACE LTD	
DRAFT			HAWKESBURY, ONTARIO, CANADA	
DESIGN BW	CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512	REV. D
DATE 01.04.19			TITLE BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4 1:20

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SHEET  
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DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)	REV. D SHEET 3 OF 4 SCALE 1:20



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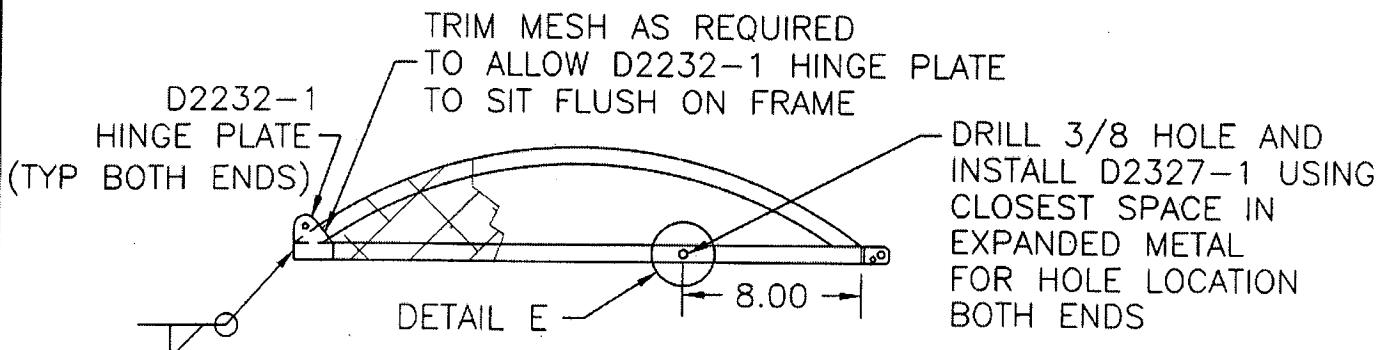
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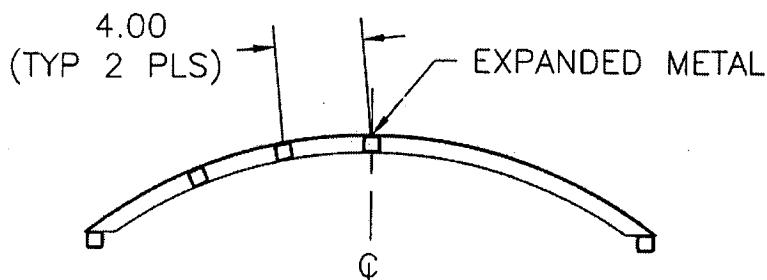
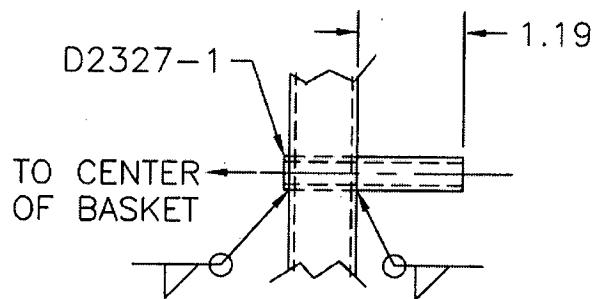


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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512
DATE 01.04.19		REV. D. SHEET 4 OF 4 SCALE 1:8 TITLE BASKET LID ASSEMBLY (350/212)



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SECTION D-D SAME BOTH CENTER RIBS

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